

Date: Friday, 16/05/2008 8:45:39 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP EXTRUSION
Job Number :	39316		
Estimate Number :	10058		
P.O. Number :		Part Number :	D2622120C
This Issue :	16/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2622 REV C1
First Issue :	/ /	Project Number :	N/A
Previous Run :	37754	Drawing Revision :	C1
	Type :	Material :	
		Due Date :	05/06/2008
Written By :		Qty:	110
Checked & Approved By :	JLD 08.5.16	Um:	Each
Comment :	Est. A: 02.11.12 New Issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 6389

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C208/05/20

(110)

2.0

D2622120CP

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s)
 Extrusion

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- Receive & Inspect For Transit Damage
- Ensure material certification is attached

P-8/6/11

126

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

- Inspect dimension per Dwg D2622
- Check Pull test per Dwg D2622 for compliance page attached
- Check hardness with Webster tester

C0606/12

(8131)

count

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/05/2008 8:45:39 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 39316

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



HALI (002)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

(54) 08/06/17

(54) +

(14) E68

(13)

(81) 08/06/13

(8R)

(14)

(14)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8.06.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

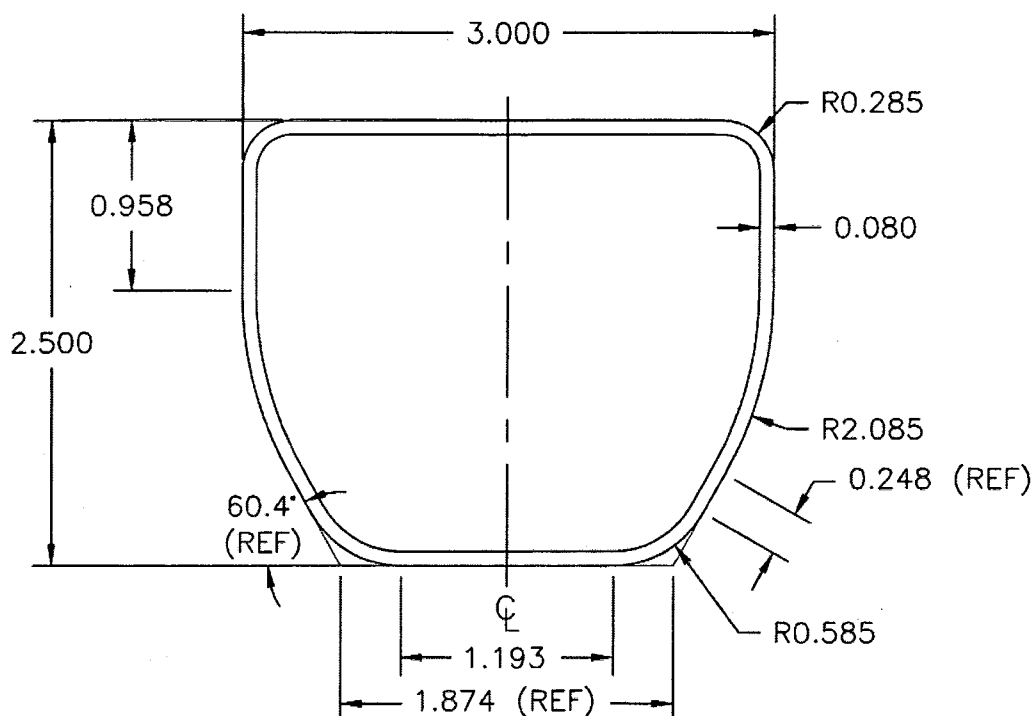
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	KE	DRAWN BY	GP	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA			
CHECKED	#	APPROVED	#	DRAWING NO.	REV. C
				D2622	SHEET 1 OF 1
DATE		TITLE		SCALE	
02.09.11		STEP EXTRUSION		1:1	
A		96.11.29		NEW ISSUE	
B		97.12.12		CHANGE MATERIAL, ADD TOL. QSI	
C		02.09.11		0.080 WAS 0.085; ADD PART & DIE No.	
C1	#	GP	02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED
02.09.11 #



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 393110

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CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert Date	Cert No	Sales Order	Page
06/09/08	177713	31374	1
Cust PO	B/L No	Lot	Date
6389	08379023	31374010	6/09/08

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622

Gross Weight	584 KGS
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Net Qty	554 KG	126 PC	384 M	3 PKG
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Specification	Die Desc
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AMS-QQ-A-200/8 & ASTM B221-06

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	314.5 / 45.6	272.4 / 39.5	11.6	.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.65	.35	.27	.06	.85	.06	.010	.06	.000	.009	.02	.000	.00
.64	.25	.24	.08	.85	.06	.000	.09	.000	.010	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc



ACCT# 00046024

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
500 EDWARD AVENUE
RICHMOND HIL ON L4C 4Y9

SHIPPING MANIFEST

MANIFEST DATE
06-09-08
MANIFEST NUMBER
641880
SALES ORDER NUMBER
31374

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCECREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CNSOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

TERMS / FREIGHT

O / P

PHONE 613-632-5200

PHONE 613-632-5200

LOCATION	TRAILER NUMBER	SALESMAN	FIELD SALES REP	CUST SERVICE REP
RIH	57368	59358	Kutter A 450-435-6551	Burton D 905-427-2227
JOB				BILL OF LADING NUMBER
				08379023

CUSTOMER ID
46024ORDER DATE
05/28/08CUSTOMER PO NUMBER
6389

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER CUSTOMER PART NUMBER	ALLOY & TEMPER LENGTH CUTTING TOLERANCE	FINISH DESCRIPTION FABRICATION DESCRIPTION SHIPPING TOLERANCE	THIS SHIPMENT			UNIT	QUANTITY DUE
							NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
01	121	KG M PC	0 0 0	DAA-897123-1 D2622	6061 /T6 120" +3/16 " -0 "	MILL CERTIFICATE OF COMP (+015-015,0139-0102)	3	584	554 384.05 126	KG M PC	0 0 0
				LOT/TKT DETAIL:		31374010 / 190929 31374010 / 190930 31374010 / 190957	1 1 1	246 265 73	236 255 63		56 PC 55 PC 15 PC
							3	584	554 384.05 126	KG M PC	
TOTALS											

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

DATE OF DELIVERY

DRIVER

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

**Purchase Order**

Date May 20, 2008	Page 1
Purchase Order Number PO00006389	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

REVISED

Vendor Address:

Signature Aluminum
1850 Clements Road
Pickering, ON L1W 3R8
Phone (800) 563-1079
Fax (800) 846-8885

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-BON001	May 20, 2008	N30	yours	Jun 05, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
✓ 121.0000 <i>New 126</i>	D2622120CP	Extrusion B39316 Comments: EXTRUDE AS PER DWG D2622 REV. C MATERIAL: 6061-T6 (QQ-A-200/8) MINIMUM YIELD TENSILE STRENGTH = 35KSI MINIMUM ULTIMATE TENSILE STRENGTH = 38KSI MINIMUM ELONGATION = 8% 120" LONG BON L CANADA INC. TOOL # 897123 REV. A TO BE PACKED PER DSK 066 PULL TEST TO ASTM STANDARD B221 REQUIRED	6/5/2008	No	28.306000	Each	3,425.03

Comments: REVISED : QTY + \$	Tax Summary:		Less: included tax	0.00
	GST	171.25		
	GSTME	0.00		
	GSTND	0.00		
	Entered By: <i>CL</i> CLAVOIE		Subtotal	3,425.03
Approved By: <i>U</i>		Total tax	171.25	
			Total purchase order in	3,596.28
			CAD Dollars	